Work Order ID 58153 Monday, April 26, 2010 2:14:32 PM							7	Page 1	
	Qty: 12.00		Cust Item II			Se	etup Stal	188 81 8	1818 181 181 188 1818 181 181 188
Approvals: Process Plan:QC:		Tooling: SPC (Y/N):		te:		R	un Sta		
Sequence ID/ Operation Work Center ID Descri	ption	Set Up/ Run Hours	Draw Number			Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr Revision Nt D4021 * B	or					•	·		
Waterjet FLOW CNC Waterjet 304 , 675 × 3,000	Memo Cut as per dwg D4021 Prog Rev: Dwg Rev: Deburr as required	0.00			-	B (0-4-7	8	3)
QC2- In QC2- I	spect parts off machine FAI/FAIB Memo	0.00			-	KB	10-4-0	8	

W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	OCEDURE CHAI	IGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes No DQA: Date:						
	R	esolution:	Disposition	:	QA: N/	C Clos	sed:		Date:		
NCR:				R NON-CONFORM							
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	Si	gn & Date	Verific Section		Approval Chief Eng	Approval QC Inspector	
		·		Onto Eng				-	,		

Work Order II Monday, April 26, 20								Page 2
Item ID: D402 Revision ID: Item Name: Hoop		Æ	Accept			s	etup Start Stop	
Start Date: 4/26/ Required Date: 4/30/ Reference:	/2010 Start Qty: 12.00	12010 1610		Cust Item II Customer:	D:		Бюр	
	cess Plan:	Date:	Tooling: SPC (Y/N):		te:	R	un Start Stop	
Sequence ID/ Work Center ID 120 QC Quality Control	Operation Description QC8- Inspect parts - second	nd check	Set Up/ Run Hours 0.00	Draw Number	Draw Plan Rev. Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
130 Small Fab Small Fab	Memo 1- make radi 2- deburr	us as per dwg	0.00			Sy	10[05]	05 (13x)
40 QC Quality Control	QC5- Inspect part complé Memo	teness to step on W/O	0.00 2 10/0	olos		43)	

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W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR:	Yes 1	No DQ	4 :	Date: _	,
		solution:								
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)		*****		
DATE	DATE STEP Description of NC Section A					Section B Verifica			Approval	Approval
			Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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Work Order ID 58153 Monday, April 26, 2010 2:14:32 PM									Page 3	
tem ID: Revision ID: tem Name: Start Date:	D4021-7 Hoop 4/26/2010 Si			Accept				Setup	Start Stop	
Required Date Reference:		tart Qty: 12.00 eq'd Qty: 12.00	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		Cust Item I Customer:	D:				
Approvals:	Process Plan:		Date:	Tooling:	Da	ate:		Run	Start	
	QC:	-	Date:	SPC (Y/N):	Da	ate:			Stop	
equence ID/ Vork Center I 50 Packaging ackaging	D De	Deration Scription Intify as per dwg & Sto Rask Memo		Set Up/ Run Hours 0.00	Draw Number	Draw Rev.		Q1) 1 10	los l	Reject Insp. Number Stamp
OC uality Control	QC	21- Final Inspection - V	Work Order Release	0.00			Co	- L101	10 1514	105/06 1

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Quality Control

Dart	Aer	osp	ace	Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ	↓ A:	Date:	
	Res	olution:	Disposition	1:	- _ QA: I	VC Clo	sed:	ç 4	Date:	
NCR:		,	WORK ORDI	ER NON-CONFORMA	NCE	(NCR)				
DATE STEP		Description of NC	Description of NC Corrective Action		Section B Ver		Verific	Verification Approval A		Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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Work Order ID: 58153

Parent Item:

D4021-7

Parent Item Name: Hoop

Comments:

IPP RevA: new issue DD 09.11 25 verified by:EC

DD 10.04.20 verified by:EC

per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB

Primary

IPP Rev:B as

Start Date: 4/26/2010

Start Qty: 12.00

Required Date: 4/30/2010

Required Qty: 12.00

Component Item ID/

M304B0.625X3.000

304 BAR .625 X 3.00

Replacement Mfg/

Purchased

Bin No

Last

Route 100

Unit of

Qty on 15.9000

Remaining 5.2623

Qty 5.8 Date

Status

图10-4-78

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			•
MAT53	15.9		
112320	. 13.1		112390

112442

2.8

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W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date:		
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DATE	Description of NC Correctiv			· · · · · · · · · · · · · · · · · · ·	Verification Approval				Approval	
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DART AEROSPACE LTD	Work Order:	58153
Description: Hoop	Part Number:	D4021-7
Inspection Dwg: D4021 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejecț	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	196	6			
0.63	+0.000/-0.005	762	7			0
1.38	+/-0.030	1. 3 68	*			
2.25	+/-0.030	2.347	b			
5.00	+/-0.030	4.994	y			
0.813	+/-0.010	,815	ب ا			
2.500	+/-0.010),505	8			
2.56	+/-0.030	7.564	7.			
0.625	+/-0.010	,693,	>			
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Measured by: B	Audited by:	Prototype Approval:	N/A
Date: 10 -4-79)	Date: (2/04/25)	Date:	N/A

Rev	Date	Change	Revised by		Approv	199
Α	10.04.01	New Issue	KJ 🛠	Y	6	7
			/	7	7	/

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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									•		
Part No:		PAR	#: Fault C	Category:	NCR: Yes No DQA: Date:						
				Disposition: C							
NCR:			WORK O	RDER NON-CONF	ORMANCE	(NCR					
DATE	STEP	Description of NC	NC	Corrective Action Section B			Verification App			Approval	
		Section A	Initial Chief Eng	Action Descript Chief Eng		Sign & Date				QC Inspector	
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5											

8 5.00 Ø0.191 -Ø0.38 R0.50 4 PL 2.25 R0.10 0.63+0.00 2 PL 45° 0.813 ==== С R1.125 Ø0.194 TYP ι Ι 0.75 R1.438 R1.75 0.63+0.00 2.500 D4021-9 BUSHING **D4021-7 HOOP** NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B MP -9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 REF DART SPEC M304R REF DART SPEC M304R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NA
7) WEIGHT -7: 0.80 lbs DESIGN AJS DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. B MFG. APPR. D4021 SHEET 3 OF 3 APPROVED SCALE DE APPR. MISC PARTS - 350 BASKET MIDO FARTI O JUDI DATONILI.

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THIS DOLLARITY AND CORPORAL AND IS LANGUED ON THE DIFFESS COMMO
THIS TO BE USED FOR ANY APPOSED ON COMPANY TO DEAL HOSPING PARTY.

MITTER PROSEDUE OF THE PROPERTY OF THE NTS DATE 10.04.06 8 .

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No					NCR: Yes No DQA: Date:						
			Disposition: (QA: N/C Closed: Date:					
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verific	cation	Approval	Approval		
			Initial Chief Eng	Action Description Chief Eng		Sign & Section		Chief Eng	QC Inspector		
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